

Date: Thursday, 15/01/2009 11:15:07 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 44815
 Estimate Number : 12712
 P.O. Number :
 This Issue : 15/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D35371
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3537 REV C
 Previous Run : 44649 Project Number : N/A
 Material :
 Due Date : 05/02/2009 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : JUD 09.01.15
 Comment : Est Rev:A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0.1113 sf(s)/Unit Total : 4.4520 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 110SS1 HB 9-1-29

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

HB 9-1-29

HB 9-1-29

(40)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Sorter counter
 50/01/25 (40)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

50 09/02/03 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 11:15:07 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 44815

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M109893

x40

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

EL 9-2-19

7.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

209-02-19 (40)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

209-02-15 (40)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: *10:15am*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *10:45am*

JH

09-02-23

x40

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/23 (40)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-17*

JH

09-02-23

x40

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



MF 09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>H4815</u>
Description: Wearpad		Part Number: D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

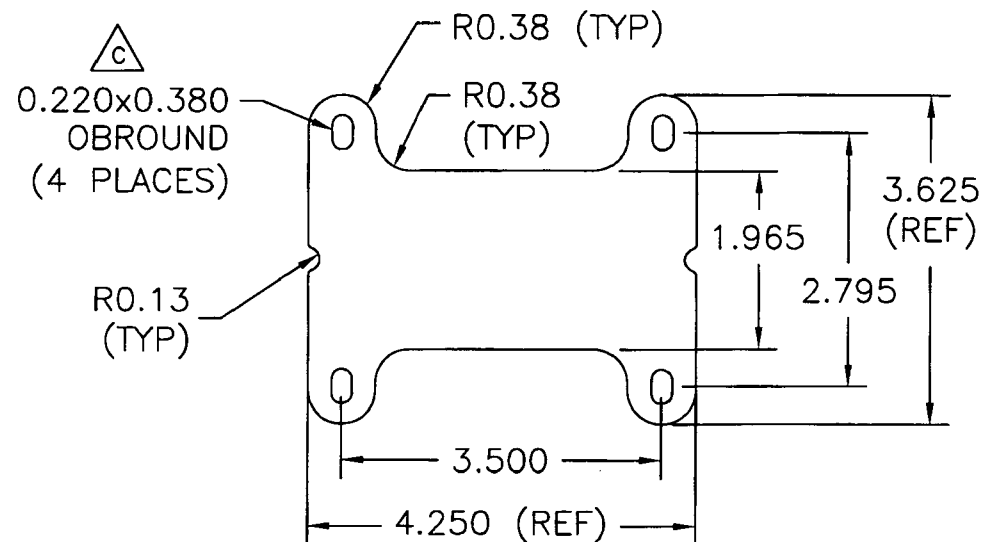
☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.248	✓			
3.500	+/-0.010	3.498	✓			
1.965	+/-0.010	1.970	✓			
2.795	+/-0.010	2.791	✓			
3.625	+/-0.010	3.624	✓			
0.220 x 0.380	+/-0.010	0.225 x 0.383	✓			

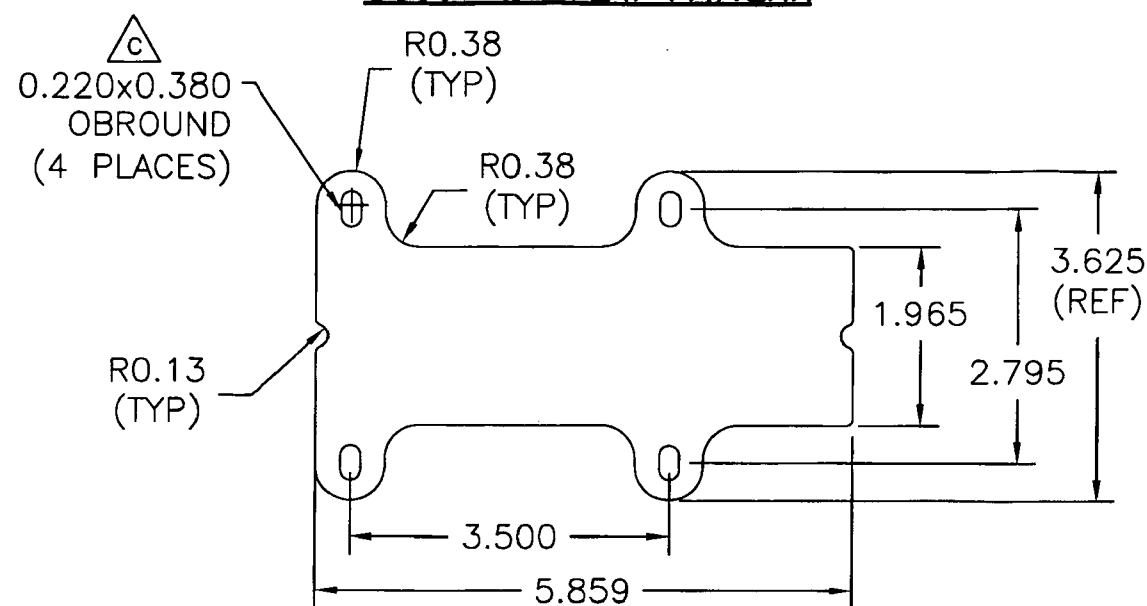
Measured by: <u>RB</u>	Audited by: <u>[Signature]</u>	Prototype Approval:	N/A
Date: <u>9-1-29</u>	Date: <u>09/01/29</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<u>[Signature]</u>

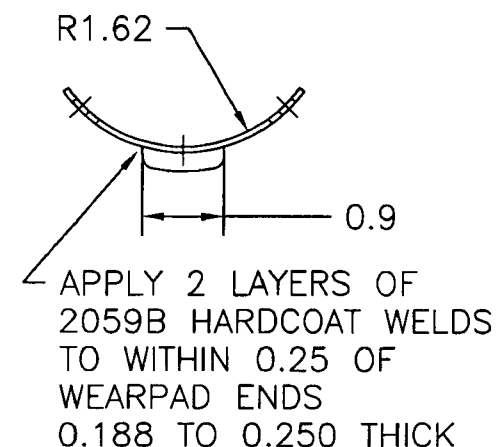
D3537-1F FLAT PATTERN



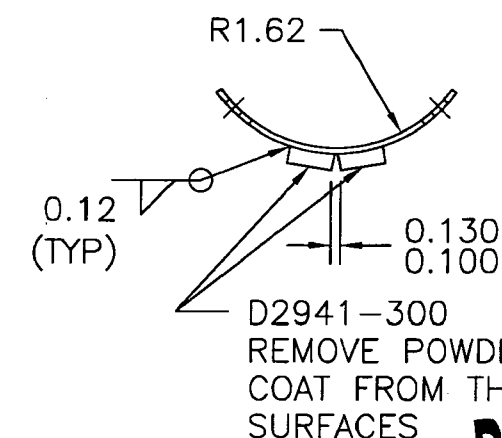
D3537-3F FLAT PATTERN



SECTION A-A

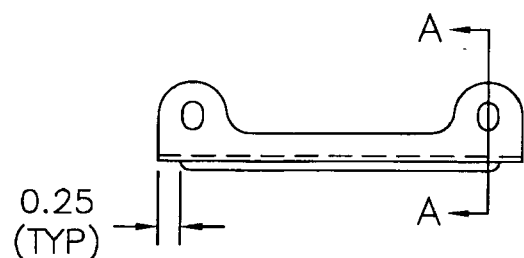


SECTION B-B



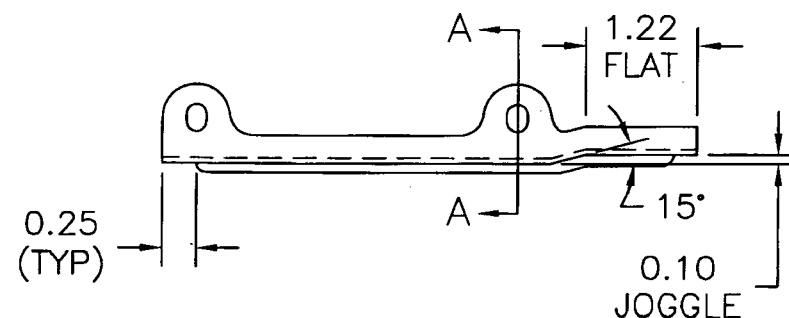
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



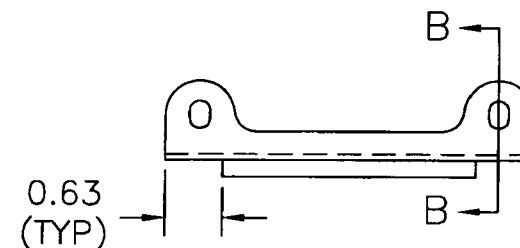
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)



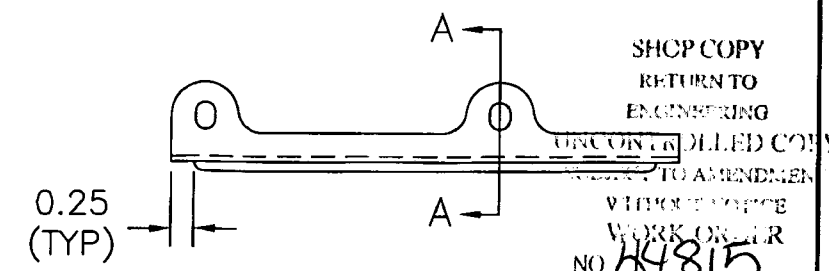
D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DART AEROSPACE USA, INC.		PORT HADLOCK, WA
DRAWING NO. D3537		REV. C SHEET 1 OF 1
		SCALE 1:2

RELEASED
07.05.08 PH
per ELN
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